



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D130-1048-042
Job Sheet 185582

Accounting Job RD17-1048-01



Part No: D130-1048-042

Job Qty: 1 ea

Part Name: EC130 Skidtube Assembly, RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/30/18

Job Tracking No:

Due Date: 11/13/18

Created By: Jesse White

Type: R+D

Description:

Note: DWG D130-1048-042 REV.A IPP REV:A 18.08.15 new issue DP Verify DD

Ship Via:

Bill of Materials



Container No: S123015



Part: D130-1048-042

Job No: 185582

Serial No/Batch: S123015

Revision: A

Inspector:

Exp Date:

Instructions:

1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/31/18

Job Routing								
Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea	11/13/18		0.00	0.00	Start Up Skid tubes-3	
150	Skid tubes	1 pcs	11/13/18		0.00	1.00	Skid tubes-2	
160	QC	1 pcs	11/13/18		0.00	0.00	QC5	
162	HandFinish	1 pcs	11/13/18		0.00	0.50	HandFinish6	
164	QC	1 pcs	11/13/18		0.00	0.00	QC7-5	
166	Outsource	1 pcs	11/13/18		0.00	0.00	Outsource2	
170	Packaging	1 pcs	11/13/18		0.00	0.00	Packaging2	
180	QC	1 pcs	11/13/18		0.00	0.00	QC6	
182	SprayPaint	1 pcs	11/13/18		0.00	1.00	Spray Paint	
184	QC	1 pcs	11/13/18		0.00	0.00	QC14	
190	HandFinish	1 pcs	11/13/18		0.00	1.00	HandFinish4	
200	QC	1 pcs	11/13/18		0.00	0.00	QC5	
230	SprayPaint	1 pcs	11/13/18		0.00	0.50	Spray Paint	
240	QC	1 pcs	11/13/18		0.00	0.00	QC14	
250	HandFinish	1 pcs	11/13/18		0.00	0.17	HandFinish4	
260	QC	1 pcs	11/13/18		0.00	0.00	QC5	
270	Packaging	1 pcs	11/13/18		0.00	0.00	Packaging3	
280	DC	1 pcs	11/13/18		0.00	0.00	DC	
290	QC21-FG	1 Ea	11/13/18		0.00	0.00	QC21	

Part Op 150 - 1-Remove bending marks longitudinally. ***Use Linemate*** 2-Identify as per note 6. 3-Insert skid tube in DT10416- Descriptions: B, position tube so that bend sect. rest against DT10443B. Bottom but FWD end against DT10443C. Use clamp to hold tube. ***BEND SECT. AND SADDLE MUST BE WITHIN 1 DEGREE OF TUBE C/L.*** Drill all pilot holes. Cleco as you drill. 4-Open holes to finish size at section B-B, C-C and D-D 5- Cleco D5571-1 saddle in previously drilled pilot holes. Transfer drill remaining saddle holes into D5611-1 skid tube. Open holes to finish size. ***SEE NOTE 11, SHEET 1, THESE ARE THE ONLY TWO HOLES THAT CAN NOT BE OPEN TO SIZE*** 6-Cleco DT10432 on two previously drilled FWD wear plate holes and drill remaining four FWD wear plate holes (SECT. E-E) Cleco DT10439 on two previously drilled AFT wear plate holes and drill remaining four AFT wear plate holes (SECT. C-C) . 7-Open holes section C-C, D-D and E-E to finished size. 8-Chamfer AFT end of tube as per DWG sheet 2 note 8. 9-Chamfer FWD end of tube as per DWG sheet 2 note 9. 10-Open blade fitting holes and deburr as per note 5. Test fit blade fitting.

166 - ISSUE P/O: 041591 Liquid Penetrant Inspection as per QSI 038 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order NDT C OF C IS REQUIRED

170 - Ensure copy of NDT results attached to work order.

182 - 1-Prime inside & outside cross tube as per DWG sheet2 note 2 and QSI 005 4.2.1.3.3 BATCH:

190 - 1-Wet install saddle with Maxibolt rivets as per DWG sheet 1 note 8 and 9 ***EXCEPT THE TWO TOP HOLES.*** Pro Seal PR-1764 B EXP ***VERY IMPORTANT TO LET A 12HR CURE TIME*** 2- As per note 11 on sheet 1. Open the top remaining holes to size, use #8 drill (0.199") 3-Touch up Alodine the two holes with ALODINE 600 4- Install the two remaining Maxibolt rivets as per dwg 5-Shave rivets as required. 6-Remove chips from inside of tube and clean tube. Prepare for final inspection.

230 - 1-Prime inside & outside cross tube as per DWG sheet1 note 2 and QSI 005 4.2.1.3.3 BATCH:

NOTEdo not paint inside saddle bore. Primer only. 2-Paint Outside of Tube as per DWG sheet 1 note 2 and Dart QSI 005 4.2.2.4 BATCH:

250 - Install inserts as per DWG sheet 1 note 10.

270 - Identify and pack for shipping as per PPP D130-1048-042 Location: _____ PPP Rev: _____

280 - Photocopy blue file & type labels per PPP D130-1048-042 CHG001

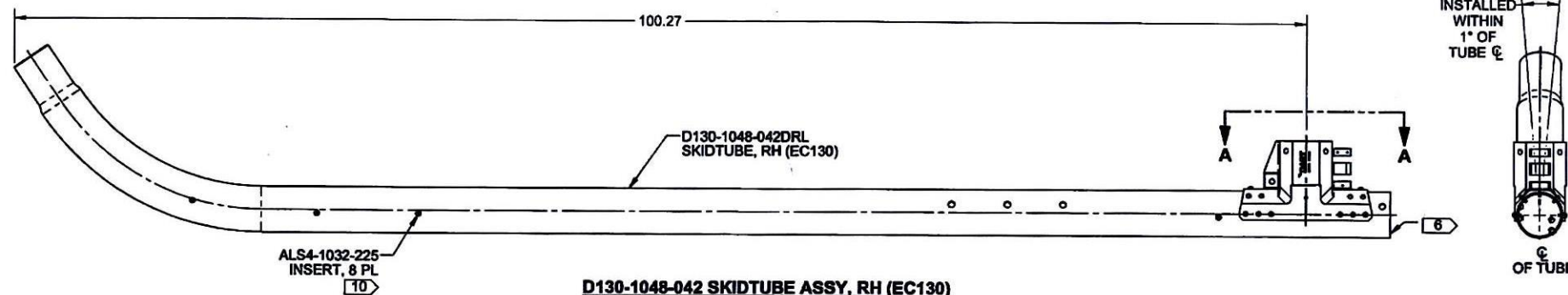
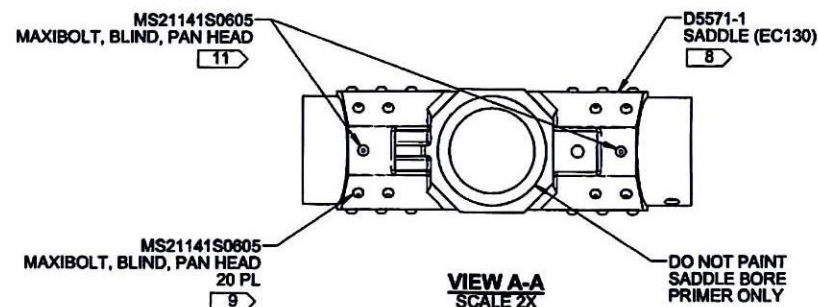
Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D5611-1	EC130 Skid tube	1 Ea (1 ea)	90-Start up Operation	00 6334
D5571-1	Saddle	1 Ea (1 ea)	150-Skid tubes	511353
CR7621S-06-05	Rivet	22 Ea (22 ea)	190-HandFinish	5118027
ALS4-1032-225	Rivnut	8 Ea (8 ea)	250-HandFinish	5128975 5102967
				5058139

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D5611-1	1	4	0
150-Skidtubes	D5571-1	1	4	0
190-HandFinish	CR7621S-06-05	22	421	0
250-HandFinish	ALS4-1032-225	8	1,735	0
Part Specifications				
Specifications could not be found.				

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QTY -042	P/N	DESCRIPTION
X	D130-1048-042	SKIDTUBE ASSY, RH (EC130)
1	D130-1048-042DRL	SKIDTUBE, RH (EC130)
1	D5571-1	SADDLE (EC130)
22	MS21141S0605	MAXIBOLT, BLIND, PAN HEAD (CR7621S06-05)
8	ALS4-1032-225	INSERT

Wp: 182417
JES



NOTES:

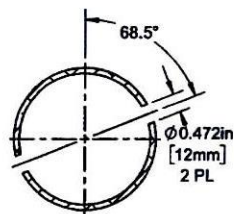
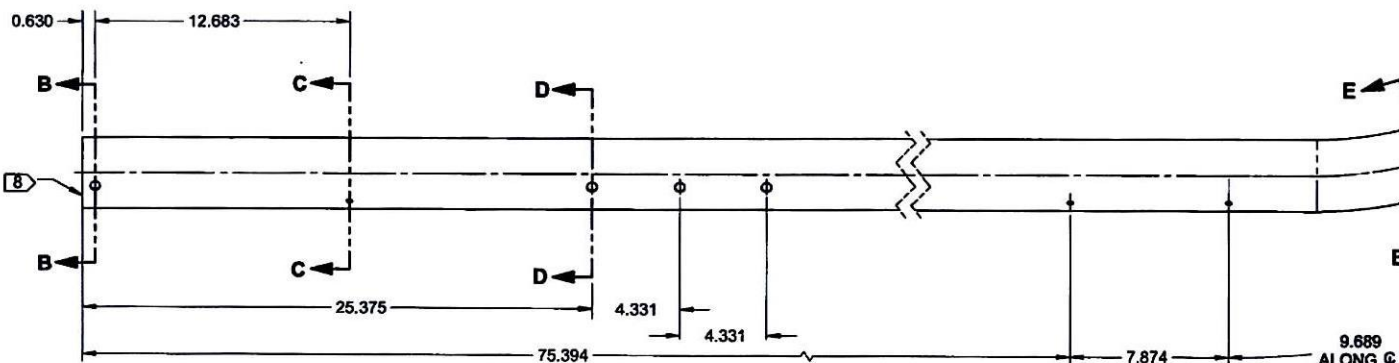
- 1) MATERIAL: N/A
- 2) FINISH: PAINT OUTSIDE PER DART QSI 005 4.2.2.4 (FLOAT SKIDTUBE PAINT) AFTER ASSEMBLY
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D130-1048-042" AND S/N PER DART QSI 044 8.4 ON INSIDE OF TUBE, MAX 0.5" FROM AFT END OF TUBE
- 7) WEIGHT: 20.33 lbs
- 8) SEAL FAYING SURFACE WITH SIKAFLEX-241/-291 OR PROSEAL 890 OR EQUIVALENT MIL-S-8802 SEALANT
- 9) POSITION SADDLE AND TRANSFER DRILL $\phi 0.193$ HOLE PATTERN FROM SADDLE ONTO SKIDTUBE. OPEN HOLES THRU SADDLE AND SKIDTUBE TO $\phi 0.199 - \phi 0.202$. TOUCH-UP HOLES WITH CHEMICAL FILM (ALODINE 1200) PER MIL-DTL-5541. WET INSTALL MAXIBOLTS WITH SIKAFLEX-241/-291 OR PROSEAL 890 OR EQUIVALENT MIL-S-8802 SEALANT
- 10) INSTALL ALS4 INSERTS IN EXISTING $\phi 0.297$ HOLES
- 11) TRANSFER DRILL $\phi 0.193$ HOLES FROM SADDLE TO SKIDTUBE. OPEN HOLES THRU SADDLE AND SKIDTUBE TO $\phi 0.199 - \phi 0.202$. ENSURE CLEAN HOLES FOR GOOD ELECTRICAL BONDING. TOUCH-UP HOLES WITH ELECTRICALLY CONDUCTIVE CHEMICAL FILM (ALODINE 600) PER MIL-DTL-5541. INSTALL MAXIBOLTS DRY (NO SEALANT).

RELEASED

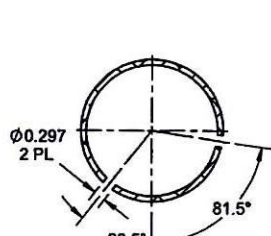
2018 OCT 02
SCN 18-017

A		NEW ISSUE		ZF	18.05.07
REV.	DESCRIPTION			BY	DATE
DESIGN	NO	DART AEROSPACE LTD			
DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA			
CHECKED	MW	DRAWING NO.		REV. A	
MFG. APPR.	JFS	D130-1048-042		SHEET 1 OF 2	
APPROVED	NO	TITLE		SCALE	
DE APPR.	CP	SKIDTUBE, RH (EC130)		NTS	
DATE	18.05.07			COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

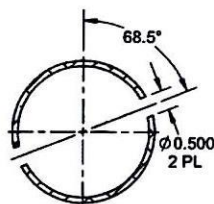
D130-1048-042DRL SKIDTUBE, RH (EC130)
(DRILLING DETAIL)



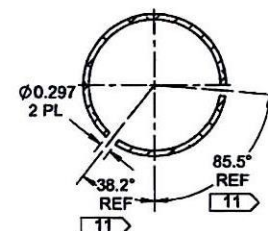
SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X, 3 PL



SECTION D-D
SCALE 2X, 3 PL



SECTION E-E
SCALE 2X

NOTES:

- 1) MATERIAL: MAKE FROM D5811-1
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2.1.3.3 (FLOAT SKIDTUBE PRIMER)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 16.37 lbs
- 8) CHAMFER ID 0.06X0.06 WHERE INDICATED
- 9) CHAMFER OD 0.06X0.06 WHERE INDICATED
- 10) LIQUID PENETRANT INSPECT OUTSIDE SURFACE PER QSI 038 PRIOR TO DRILLING.
- 11) LOCATE HOLES USING DRILLING JIG DT10432.

RELEASED

2018 OCT 02

APPROVED

DESIGN	NO	DART AEROSPACE LTD	
DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MW	DRAWING NO.	REV. A
MFG. APPR.	JFS	D130-1048-042	SHEET 2 OF 2
APPROVED	NO	TITLE	SCALE
DE APPR.	CP	SKIDTUBE, RH (EC130)	NTS
DATE	18.05.07	COPYRIGHT © 2018 BY DART AEROSPACE LTD	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: <u>182417</u> Part No. <u>D130-1048-042</u>	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☒ Quality ☐		
Date : <u>18-11-07</u>	Sequence #: <u>150</u>	QTY Affected : <u>①</u>	MRB (QSI042) <u>INSP 12</u> <u>18/11/07</u>	
Description Work Order Deviation <u>D5611-1 supplied un cut</u>		Disposition <u>Cut tubes to length per D5611 Rev A. Total length should be 106.83</u>		Completed By <u>DAS 9 18-11-07</u>
Root Cause Operator ☒ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☒ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		
Other/Details:				



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041591**

Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

PO No: PO041591
PO Date: 11/5/18
Due Date: 11/9/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:

Special Comments: please note po041568 was open an cancelfor the jobs same as po041591

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	181665	D350-748-103	AS350 / AS355 Stainless Steel Fwd Crosstube : TC STC SH06-27 Issue 2, FAA STC SR02359NY 11/03/04, EASA STC EASA.10016903 Revision 2 10/09/03, BRAZIL 2009S04-04 09/04/06 ISSUE P/O TO SKY SERVICE: _____	Firmed	-	11/9/18	1 pcs	0 pcs	1 pcs	\$145.00/pcs	\$145.00
2	185582	D130-1048-042	EC130 Skidtube Assembly, RH ISSUE P/O: _____ Liquid Penetrant Inspection as per QSI 038 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order NDT C OF C IS REQUIRED	Firmed	-	11/9/18	1 pcs	0 pcs	1 pcs	\$133.75/pcs	\$133.75
	185581			Firmed	-	11/9/18	1 pcs	0 pcs	1 pcs	\$133.75/pcs	\$133.75
Sub Total:							2	0	2		\$267.50

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1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
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PURCHASE ORDER **PO041591**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	185578	D130-1048-041	EC130 Skidtube Assembly, LH ISSUE P/O: _____ Liquid Penetrant Inspection as per QSI 038 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order NDT C OF C IS REQUIRED	Firmed	-	11/9/18	1 pcs	0 pcs	1 pcs	\$133.75/pcs	\$133.75
	185580		1 X NOV 05 2018	Firmed	-	11/9/18	1 pcs	0 pcs	1 pcs	\$133.75/pcs	\$133.75
Sub Total:							2	0	2		\$267.50
4	182064	D130-1048-141	EC130 Fwd Crosstube *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** ISSUE P/O: _____ Liquid Penetrant Inspection as per QSI 038 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order NDT C OF C IS REQUIRED	Firmed	-	11/9/18	1 pcs	0 pcs	1 pcs	\$133.75/pcs	\$133.75
	182059		1 X NOV 05 2018	Firmed	-	11/9/18	1 pcs	0 pcs	1 pcs	\$133.75/pcs	\$133.75
Sub Total:							2	0	2		\$267.50
5	182056	D130-1048-241	EC130 Aft Crosstube *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** ISSUE P/O: _____ Liquid Penetrant Inspection as per QSI 038 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order NDT C OF C IS REQUIRED	Firmed	-	11/9/18	1 pcs	0 pcs	1 pcs	\$75.00/pcs	\$75.00
	182057		1 X NOV 05 2018	Firmed	-	11/9/18	1 pcs	0 pcs	1 pcs	\$75.00/pcs	\$75.00
Sub Total:							2	0	2		\$150.00
Grand Total:										\$1,097.50	

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO041591

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

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skyservice Work Order Traveler

Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO38034	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PO041568 ✓
Descr:	PN:	S/N:	Qty: 1 <i>PO041591</i>
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT (LIQUID PENETRANT CRACK TEST) ON THE FOLLOWING 5 CROSSTUBES AND 4 SKIDTUBES:

P/N: D130-1048-141 FWD CROSSTUBE

1- JOB SHEET# 182064 ✓ 2- JOB SHEET# 182059 ✓

P/N: D130-1048-241 AFT CROSSTUBE

3- JOB SHEET# 182056 ✓ 4- JOB SHEET# 182057 ✓

P/N: P/N: D350-748-103 FWD CROSSTUBE

5- JOB SHEET# 181665 ✓

P/N: P/N: D130-1048-041 EC130 SKIDTUBE LH

6- JOB SHEET# 185580 ✓ 7- JOB SHEET# 185578 ✓

P/N: P/N: D130-1048-042 EC130 SKIDTUBE RH

8- JOB SHEET# 185581 ✓ 9- JOB SHEET# 185582 ✓

DAS
68
9-89

Action Taken:		Date:	Initial/Stamp:		
LIQUID PENETRANT INSPECTION CARRIED OUT ON ITEMS LISTED ABOVE (ITEMS 1-9) AS PER ASTM1417M-16		<i>2 NOV 2018</i>			
-NO CRACK FOUND.					
PEN.(ZL-56, MPO13600), DEV.(SKD-S2, MPO11715), CLEANER(SKC-S, MPO MPO19368)					
Description	Location P/N	Qty	Batch	S/N Off	S/N On

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	ACA/SCA Stamp 	Date: <i>2 NOV 2018</i>
Name: CHRISTIAN BRIEN		



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041606**

Supplier: ATE003-VC
Atelier Debosselage
358 Principale
Calumet
QC
J0V 1B0 Canada
Phone: 819 242 5633

PO No: PO041606
PO Date: 11/6/18
Due Date: 11/9/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, Chrisoula
Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	185581	D130-1048-042	EC130 Skidtube Assembly, RH Issue P/O to Atelier Debosselage: _____ ***MASK PRIOR TO PRIME AND PAINT AS PER NOTE 9*** *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** ***NOTE***do not paint inside saddle bore. Primer only. 1- PRIME INSIDE AND OUTSIDE PER DWG (FLOAT SKIDTUBE PRIMER) 2- PAINT OUTSIDE SURFACE AS PER DWG NOTE2 (FLOAT SKIDTUBE PAINT)	Firmed	-	11/9/18	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
	185582			Firmed	-	11/9/18	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
Sub Total:							2	0	2		\$450.00



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Hawkesbury, ON
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PURCHASE ORDER **PO041606**

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
2	185578	D130-1048-041	EC130 Skidtube Assembly, LH Issue P/O to Atelier Debosselage: _____ ***MASK PRIOR TO PRIME AND PAINT AS PER NOTE 9*** *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** ***NOTE***do not paint inside saddle bore. Primer only. 1- PRIME INSIDE AND OUTSIDE PER DWG (FLOAT SKIDTUBE PRIMER) 2- PAINT OUTSIDE SURFACE AS PER DWG NOTE2 (FLOAT SKIDTUBE PAINT)	Firmed	-	11/9/18	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
	185580			Firmed	-	11/9/18	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
Sub Total:							2	0	2		\$450.00
Grand Total:										\$900.00	

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/6/18 8:41 AM dart.tsimiklis.chrisoula